



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-201TRN
Job Sheet 173482



Part No: D212-664-201TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/15/18	3/15/18	0.00	0.00	Start Up Crosstubes-2		PMP
100	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
110	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		PMP
120	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
130	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		PMP
140	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC8		GA
145	Crosstubes	1 pcs	3/15/18	3/15/18	0.00	0.25	Crosstubes-2		GA
150	HandFXtube	1 pcs	3/16/18	3/16/18	0.00	0.25	Crosstubes-3		SA 18-0501
160	QC	1 pcs	3/16/18	3/16/18	0.00	0.00	QC7-1		GA
170	Packaging	1 pcs	3/16/18	3/16/18	0.00	0.00	Packaging3-1		GA
180	QC21-SA	1 Ea	3/16/18	3/16/18	0.00	0.00	QC21		GA

Part Op 100 - 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114 2-Turn first side as per Folio FA114
 Descriptions: 120 - 1-Turn second side as per Folio FA114
 145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - 1- handfinish X-TUBE INSIDE AND OUT
 170 - Identify and stock in kanban rack Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6006-129	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6006-129	1	71	0

B123 969

Part Specifications

Specifications could not be found.

Plex 3/2/18 10:41 AM Dart.Gagnon.Michelle



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Container No: S050152



Part: D212-664-201TRN

Job No: 173482

Serial No/Batch: S050152

Revision:
Inspector:

Date: 03/12/18

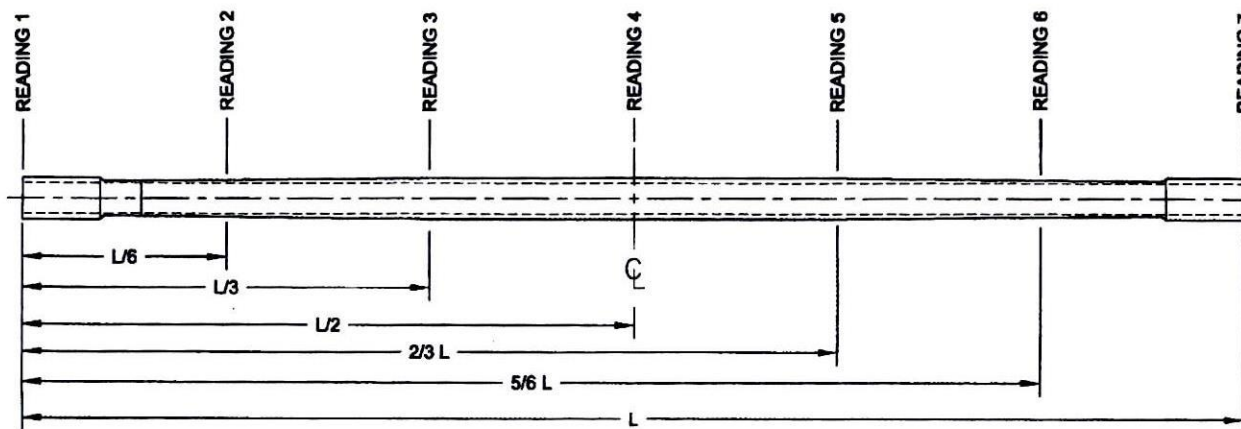
DART AEROSPACE LTD	Work Order: 173482
Description: Crosstube Assembly (205/212 High Aft)	Part Number: D212-664-241
Inspection Dwg: D212-664-241 Rev: E	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.199	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.992	✓		VERN 08	
	5.237	+/-0.030	5.239	✓		"	
	2.600	+0.005/-0.000	2.605	✓		RLM 2"-3"04	
	2.686	+0.005/-0.000	2.690	✓		"	
	2.770	+0.005/-0.000	2.775	✓		"	
	2.854	+0.005/-0.000	2.859	✓		"	
	2.938	+0.005/-0.000	2.941	✓		"	
	3.021	+0.005/-0.000	3.026	✓		RLM 3"-4"05	
	3.133	+0.005/-0.000	3.138	✓		"	
	3.179	+0.005/-0.000	3.183	✓		"	
	.500	±.010	.500	✓		RG	
	.063	±.010	.063	✓		RG	
	0.200	+/-0.010	.201	✓		VERN 08	
SIDE B	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.9935	✓		VERN 08	
	5.237	+/-0.030	5.232	✓		VERN 08	
	2.600	+0.005/-0.000	2.605	✓		RLM 2"-3"04	
	2.686	+0.005/-0.000	2.6905	✓		"	
	2.770	+0.005/-0.000	2.774	✓		RLM "	
	2.854	+0.005/-0.000	2.8575	✓		"	
	2.938	+0.005/-0.000	2.93415	✓		"	
	3.021	+0.005/-0.000	3.026	✓		RLM 3"-4"05	
	3.133	+0.005/-0.000	3.137	✓		"	
	3.179	+0.005/-0.000	3.184	✓		"	
	124.362	+/-0.020	124.360	✓		TAPE	
	.500	±.010	.500	✓		RG	
	.063	±.010	.063	✓		RG	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	409	395	397	412	.017	0.062"
READING 2 L = 20.73	332	335	317	314	.021	
READING 3 L = 41.45	500	503	482	479	.024	
READING 4 L = 62.18	540	534	512	513	.028	
READING 5 L = 82.91	503	497	483	485	.020	
READING 6 L = 103.64	314	327	334	320	.020	
READING 7 L = 124.36	401	396	405	415	.019	

Calibration Result

Actual Block Thickness: 300-500

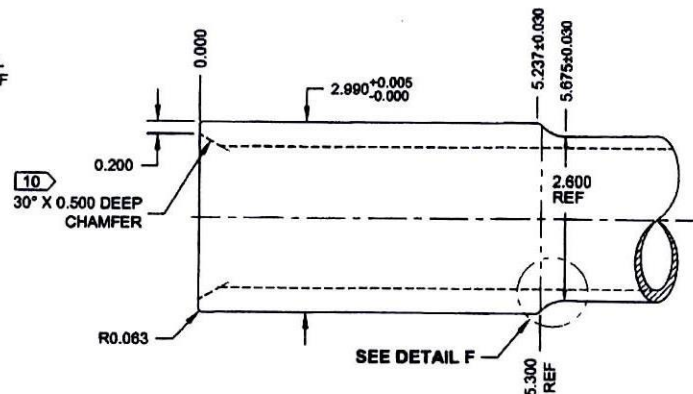
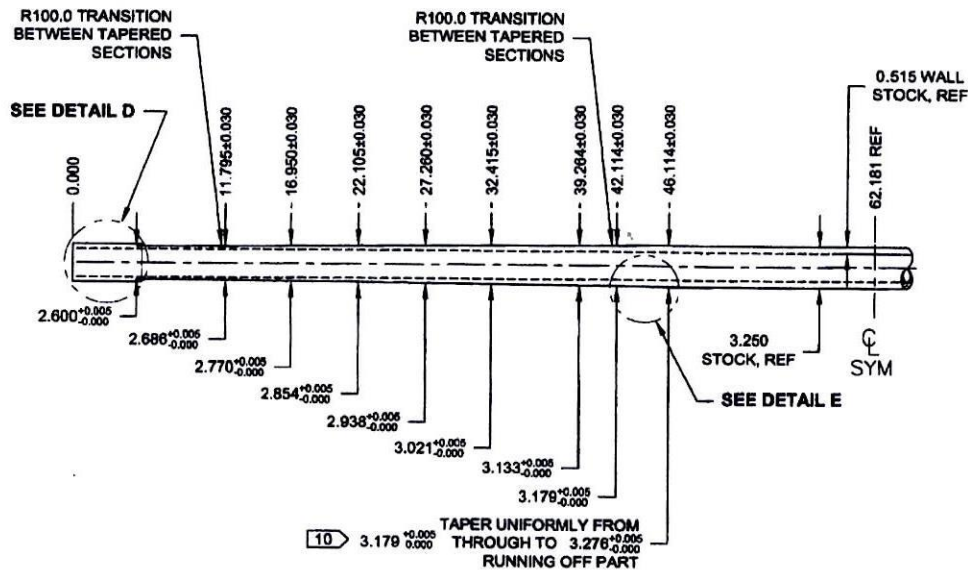
Sitescan 250 Measured Thickness: 300-500

Measured by:	JMP
Date:	2018-03-12

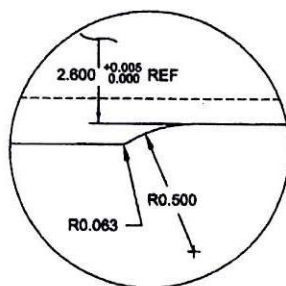
Audited by:	
Date:	

Preliminary Approval:	
Date:	

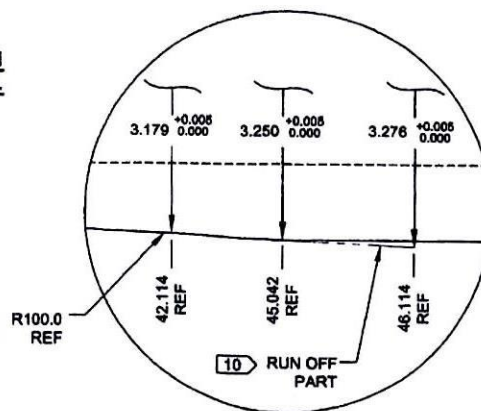
Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	15.03.03	Dwg Rev updated	KJ	



DETAIL D:
 CROSSTUBE CUFF
 SCALE 1X
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 173482
 MAR 02 2018



DETAIL F:
 CUFF TRANSITION
 SCALE 10X



DETAIL E:
 TAPER RUN-OFF
 NOT TO SCALE

RELEASED
 2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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